

Date: Friday, 23/03/2007 6:06:58 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE BRACKET HI-SLOPE
Job Number : 31334	
Estimate Number : 11004	
P.O. Number : N/A	Part Number : D2606
This Issue : 23/03/2007 S.O. No. : N/A	Drawing Number : D2606 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 31334	Material : N/A
Written By :	Due Date : 10/04/2007 Qty: 20 Um: Each
Checked & Approved By :	
Comment : Est. D 98.11.26 Added Inspection DM Est Rev:E Now On Waterjet 07-03-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.1582 sf(s)/Unit Total : 3.1647 sf(s)
2024-T3 .040 sheet
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
Stack of 10
(M2024T3S.040) Batch m104025

07 04 19

20

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D2606
Dwg Rev: A1
Prog Rev: A1

ml 07 04 19

20

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 04 19

20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

2004-24 20 counted.

Date: Friday, 23/03/2007 6:06:58 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET HI-SLOPE

Job Number: 31334

Part Number: D2606

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2606

SAD 07/05/03 (20)

SB 07/05/04 (20)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 07/05/08 (20X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/05/08 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/08 (20)

9.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07/05/08 (20)

Job Completion



07/05/08

5.1 QCS

07/05/07 (20)

Date: Tuesday, 3/20/2007 12:03:31 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE BRACKET HI-SLOPE
Job Number	: 31334		
Estimate Number	: 11004		
P.O. Number	:	Part Number	: D2606
This Issue	: 3/20/2007 S.O. No. :	Drawing Number	: D2606 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 25142	Material	:
Written By	:	Due Date	: 4/10/2007 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est. / D 98.11.26 Added Inspection DM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S040

2024-T3 .040 sheet



Comment: Qty.: 0.1582 sf(s)/Unit. Total : 3.1647 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 Stack of 10
 (M2024T3S.040) Batch _____

W3 forget

2.0

SHEAR

SHEAR



Comment: SHEAR
 Cut Blank per template DT8247

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2606

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
070507	5.0	Add Qc S Perm. Change						
	5	Qc S		070507	20	070507	070507	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:03:31 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET HI-SLOPE

Job Number: 31334

Part Number: D2606

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2606

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 0054.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

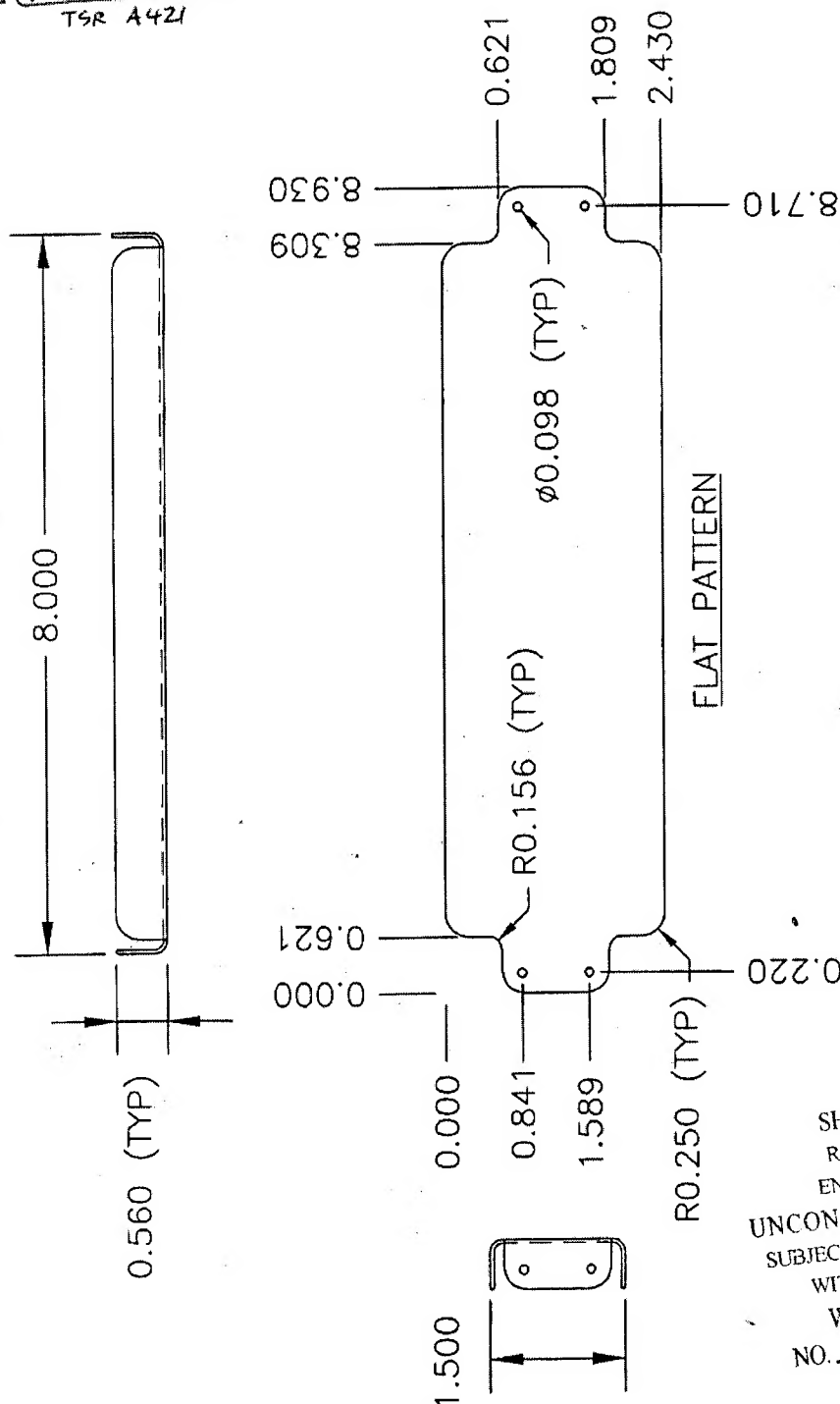
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

COPIES

DESIGN <i>[Signature]</i>	DRAWN BY Bw	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO: D2606	REV. A SHEET 1 OF 1
DATE 97.10.23		TITLE CONSOLE BRACKET	SCALE 1:2
A	97.10.23	D2606 WAS D206-547-27	
A1 <i>[Signature]</i>	02.06.04	ADD FINISH	

TSR A421



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31334

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
 PROFILE CONTROLLED BY FOLIO H2606
 BEND RADIUS 0.093
 FINISH: CHEMICAL CONVERSION COAT PER DART Q51 005